



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D3574-1

Job Sheet 196039



Part No: D3574-1

Job Qty: 2 pcs

Part Name: Cabin Floor Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/5/19

Job Tracking No:

Due Date: 6/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev :A New Issue 07-01-22 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs	6/17/19	6/17/19	0.17	0.91	Waterjet - Flow		19/06/12
110	QC 2	2 pcs	6/17/19	6/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		19/06/12
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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JUN 13 2019

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	2 pcs	6/17/19	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		
				QC 21 - SA - 53		
Part Op 110 - QC2- Inspect parts off machine FAI/FAIB Descriptions: 120 - QC8- Inspect parts - second check 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
MLEXS.125-F60029-04	GE Plastics Lexan Sheet (Dark Grey)	64 sf (32 ea)	100-Waterjet - Flow - 1	5165915		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Waterjet - Flow - 1	MLEXS.125-F60029-04	64	2,965	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order:	196039
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.00	/		VDC-02	
7.37	+/-0.030	7.35	/		Tape	
10.75	+/-0.030	10.75	/			
11.00	+/-0.030	11.00	/			
15.25	+/-0.030	15.20	/			
25.87	+/-0.030	25.87	/			
39.75	+/-0.030	39.75	/			
44.75	+/-0.030	44.75	/			
49.11	+/-0.030	49.10	/			
51.11	+/-0.030	51.10	/			
53.51	+/-0.030	53.50	/			
63.50	+/-0.030	63.50	/			
65.25	+/-0.030	65.20	/			
10.75	+/-0.030	10.75	/			
11.06	+/-0.030	11.00	/			
14.75	+/-0.030	14.75	/			
25.50	+/-0.030	25.50	/			
25.75	+/-0.030	25.70	/			
26.00	+/-0.030	26.00	/			
32.87	+/-0.030	32.85	/			
38.81	+/-0.030	38.80	/			
44.75	+/-0.030	44.75	/			
45.00	+/-0.030	45.00	/			
48.25	+/-0.030	48.20	/			
58.38	+/-0.030	58.39	/			
61.25	+/-0.030	61.20	/			
64.13	+/-0.030	64.15	/			
64.63	+/-0.030	64.63	/			
66.50	+/-0.030	66.53	/			
7.50	+/-0.030	7.50	/			
9.50	+/-0.030	9.50	/			
10.38	+/-0.030	10.36	/			
10.88	+/-0.030	10.90	/			
14.50	+/-0.030	14.59	/			

DART AEROSPACE LTD		Work Order: 196089
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	/		VOL-02	
18.75	+/-0.030	18.75	/		TAP	
24.13	+/-0.030	24.13	/			
26.50	+/-0.030	26.50	/			
30.50	+/-0.030	30.50	/			
33.88	+/-0.030	33.85	/			
39.50	+/-0.030	39.50	/			
40.25	+/-0.030	40.25	/			
43.50	+/-0.030	43.55	/			
43.83	+/-0.030	43.80	/			
46.60	+/-0.030	46.65	/			
7.63	+/-0.030	7.60	/			
11.00	+/-0.030	11.00	/			
11.50	+/-0.030	11.50	/			
16.75	+/-0.030	16.75	/			
19.00	+/-0.030	19.00	/			
22.50	+/-0.030	22.50	/			
30.75	+/-0.030	30.75	/			
32.63	+/-0.030	32.63	/			
32.75	+/-0.030	32.75	/			
35.13	+/-0.030	35.13	/			
36.50	+/-0.030	36.50	/			
40.00	+/-0.030	40.00	/			
41.88	+/-0.030	41.88	/			
43.63	+/-0.030	43.63	/			
0.125	+/-0.010	0.126	/			

Measured by: JRB	Audited by: DAS 40	Prototype Approval:	N/A
Date: 6/12/19	Date: JUN 13 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S189689



Part: D3574-1

Job No: 196039

Serial No/Batch: S189689

Revision:

Inspector:

Expiry Date:

Instructions: Various

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Date: 06/12/19